Work Orde								The second distance of			·	Page
Revision ID:	D3204-9 Pedal			Accept					Setup	Start Stop		
	1/6/2011	Start Qty: 4.00 Req'd Qty: 4.00	1.488 6.0. 1001		Cust Item I Customer:	D:				ж		
Approvals:	Process Pla	n:	Date://-//	Tooling: SPC (Y/N):		ite:		1	Run	Start Stop		
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr							- 			
D3204	Rev	A1		•								
Bandsaw Jeaspa Bandsaw		BAND SAW Memo Cut blan	k: 2.000" x 0.375" x 3.100" lon	0.00 0.00 g Bar	11/03/22		(A)				
HAAS I	machine #1	Memo	CAL MACHINING #1 ine as per Folio FA357 and Dwg	0.00	rel 11/04/ Hentify as D3204-	01		<u></u> 4	/ -			

120

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00 Cul uloy/or

Quality Control

Work	Order	ID	651	4 1
4 4 O 1 IX	Oluci	11/	OOT.	T J

Thursday, January 06, 2011 3:29:15 PM



Page 2

Item ID:

D3204-9

Accept

Setup Start



Revision ID:

Start Date:

Item Name:

Required Date: 1/14/2011

Pedal 1/6/2011

Start Otv: 4.00

Req'd Oty: 4.00



Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

Date:

Date:

Tooling: SPC (Y/N): Date:

Date:

Run Start

Stop

Stop



OC:

Sequence ID/ Work Center ID

130

Quality Control

Operation Description

QC8- Inspect parts - second check

Set Up/ Run Hours

Tool ID

Tool # Plan Code

Accept Reject Qty Qty

Reject

Insp. Number Stamp

Memo

0.00

140

Packaging

Packaging

Memo

Memo

Identify as per dwg & Stock Location.

*****STOCK IN LARGE FAB*****

0.00

0.00

150

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

U (1104.05

Picklist Print

Thursday, January 06, 2011 3:29:20 PM

Work Order ID: 65141

Parent Item:

D3204-9

Parent Item Name: Pedal



Start Date: 1/6/2011

Required Date: 1/14/2011

Page 1

Start Qty: 4.00

Required Qty: 4.00

Comments:

□C□05.08.11□Added Step 25□ KJ/JLM□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	· . ·	 Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.375X02.00		Purchased	No		100	f	21.8023	0.2688	1.131789			



6061-T6 Bar .375 x 2.00

Loc Qty Loc Code

Location MAT 20 114488 20 MAT01 1.8023 19059 1.8023

DART AEROSPACE LTD	Work Order:	65141
Description: Pedal	Part Number:	D3204-9
Inspection Dwg: D3204 Rev: A1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.50	+/-0.030	·520			Vern 41	ンフ
0.250	+/-0.010	245	_		71	
0.080	+/-0.010	,083			l.	
0.110 x 45°	+/-0.010	.100×450			46	
0.620	+/-0.010	.620			14	
3.000	+/-0.010	3,000	1		. ,	
2.00	+/-0.030	2.000			11	
0.310	+0.010/-0.000	· 312	_		10	
0.780	+/-0.010	.780			10	
1.750	+/-0.010	1.755			.,	
Ø0.134	+0.005/-0.000	p. 135			16	
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Date:	1/04/01	Date: 11/04/04	Date:	N/A

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Α	05.02.17	New Issue	KJ/JLM ,	-1
В	06.03.21	Dwg Rev update	KJ/JLM o	

	Dart	Aeros	pace	Ltd
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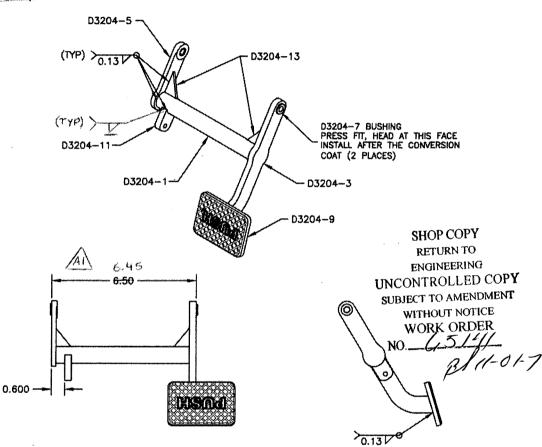
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	04.0)1.27		RELEASE PEDAL ASSEMBLY	NTS
	Α		04.01.27	NEW ISSUE	

6.45 WAS 6.50



05.07.15

D3204-041 RELEASE PEDAL ASSEMBLY

NOTES

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
 ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020
 ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
 WELD ASSEMBLY PER QSI 004

- 9) POWDER CONVERSION COAT PER DART QSI 005 4.1
 9) POWDER COAT ASSEMBLY GREY SANDTEX (REF. 4.3.5.6) PER QSI 005 4.3
 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 11) ALL DIMENSIONS ARE INCHES

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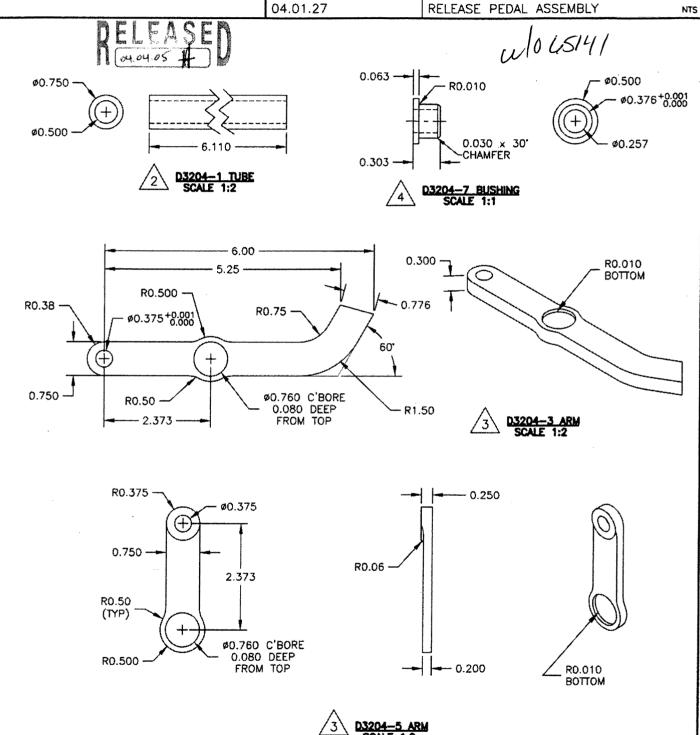
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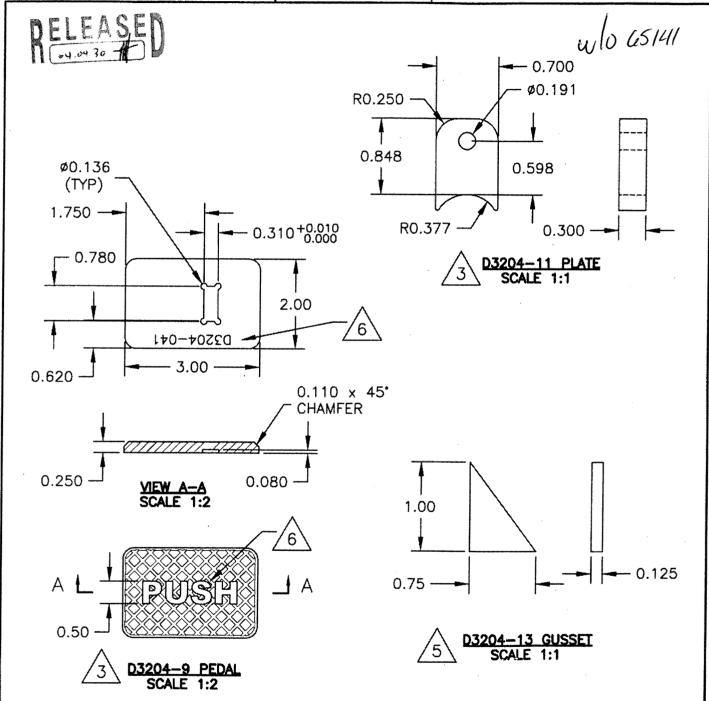
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